

JIG DESIGN

in turn, forces out plunger *H* and throws the work against stop-pin *I*; second, a downward pull on plunger *K*, drawing down the clamp *L*. Thus the work is thrown against the stop-pins before the final clamping pressure is applied. Clamps *C* and *L* are held up by spring plungers, not shown.

The clamping pressure on eight small washers is equalized, and the washers clamped with a down-and-in movement in the

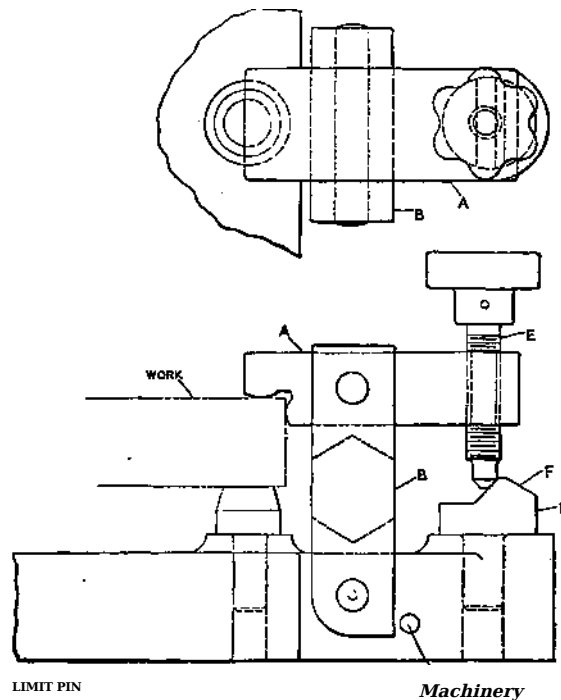


Fig. 8. Another Type of Double Movement Clamp

fixture shown in Fig. n. Rod *A* clamps the equalizers *B* and *C*, which equalize the pressure against *D* and *E* on the one side, and *JP* and *G* on the other. Clamps *D*, *E*, *F*, and *G* are given a downward pull by four plungers *H*, which also impart a downward pull on the inner clamps *I*, *K*, *L*, and *M*. The clamps are bored to receive the washers, and are returned to a normal position by the spring plungers *N*.